

What is claimed is:

1. In a joint structure between a core layer 2 and a skin layer 3 for manufacturing a partial foaming part 1 of which a polyurethane foam layer 4 is formed
5 between the core layer 2 and the skin layer 3, characterized by comprising:

a partial end portion 31 being curved inwards within the polyurethane foam layer 4 at a front end of the skin layer 3 that is correspond to a joint part between the core layer 2 and the skin layer 3; and

a skin end portion 32 upwardly extending from an end of the partial end portion
10 31 and being pressed against the core layer 2 due to foaming pressure of the polyurethane foam layer 4,

wherein a foam staying space 33 is provided between an inner side surface of the core layer 2 and the skin end portion 32 of the skin layer 3.

15 2. The joint structure according to claim 1, characterized by the fact of flow control walls 21, 21', for preventing a polyurethane foam from being overflowed directly between the inner side surface of the core layer 2 and an end of the skin layer 3, downwardly protruding from an inner upper surface of the core layer 2 above the joint part of the core layer 2 and the skin layer 3.

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3. In a joint structure between a core layer 2 and a skin layer 3 for manufacturing a partial foaming part 1 of which a polyurethane foam layer 4 is formed between the core layer 2 and the skin layer 3, characterized by comprising:

a partial end portion 34 being curved inwards from an inner side surface of the

core layer 2 within the polyurethane foam layer 4 at a front end of the skin layer 3 that is correspond to a joint part between the core layer 2 and the skin layer 3;

5 a skin end portion 35 upwardly extending from an end of the partial end portion 34 and being pressed against the core layer 2 due to foaming pressure of the polyurethane foam layer 4; and

10 a foam leakage-preventing protrusion 22, for preventing a polyurethane foam from being leaking, protruding from the inner side surface of the core layer 2 which is correspond to the joint part between the core layer 2 and the skin layer 3, the foam leakage-preventing protrusion 22 being contacted with the partial end portion 34 of the skin layer 3;

wherein a foam staying space 36 is provided between the foam leakage-preventing protrusion 22 and the skin end portion 35.

15 4. The joint structure according to claim 3, characterized by the fact of a pair of foam leakage-preventing protrusions 22 protruding from the inner side surface of the core layer 2 which is correspond to the joint part of the core layer 2 and the skin layer 3, in which a foam staying space 36 is provided between the foam leakage-preventing protrusions 22 and the skin layer 3.

20 5. The joint structure according to claims 3 or 4, characterized by the fact of flow control walls 21, 21', for preventing a polyurethane foam from being overflowed directly between the inner side surface of the core layer 2 and an end of the skin layer 3, downwardly protruding from an inner upper surface of the core layer 2 above the joint part of the core layer 2 and the skin layer 3.

6. In a joint structure between a core layer 2 and a skin layer 3 for manufacturing a partial foaming part 1 of which a polyurethane foam layer 4 is formed between the core layer 2 and the skin layer 3, characterized by comprising:

5 a groove 23 for providing a foam staying space 37 therein being formed at an inner side surface of the core layer 2 which is correspond to a joint part of the core layer 2 and the skin layer 3,

a front portion of the skin layer 3 longitudinally extending along the front surface of the core layer 2 so that it may be tightly contacted with the inner side surface of the
10 core layer 2 in which the groove 23 is formed.

7. The joint structure according to claim 6, characterized by the fact of flow control walls 21, 21', for preventing a polyurethane foam from being overflowed directly between the inner side surface of the core layer 2 and an end of the skin layer 3,
15 downwardly protruding from an inner upper surface of the core layer 2 above the joint part of the core layer 2 and the skin layer 3.

8. In a joint structure between a core layer 2 and a skin layer 3 for manufacturing a partial foaming part 1 of which a polyurethane foam layer 4 is formed
20 between the core layer 2 and the skin layer 3, characterized by comprising:

a partial end portion 38 being curved inwards from an inner side surface of the core layer 2 within the polyurethane foam layer 4 at a front end of the skin layer 3 that is correspond to a joint part between the core layer 2 and the skin layer 3;

a foam leakage-preventing protrusion 24, for preventing a polyurethane foam

from being leaking, protruding from the inner side surface of the core layer 2 which is correspond to the joint part between the core layer 2 and the skin layer 3, the foam leakage-preventing protrusion 24 being curved with corresponding to the shape of the partial end portion 34 of the skin layer 3; and

5 a groove 25 for providing a foam staying space therein being formed at the inner side surface of the core layer 2 below the foam leakage-preventing protrusion 24.

9. The joint structure according to claim 8, characterized by the fact of flow control walls 21, 21', for preventing a polyurethane foam from being overflowed directly
10 between the inner side surface of the core layer 2 and an end of the skin layer 3, downwardly protruding from an inner upper surface of the core layer 2 above the joint part of the core layer 2 and the skin layer 3.

10. In a joint structure between a core layer 2 and a skin layer 3 for
15 manufacturing a partial foaming part 1 of which a polyurethane foam layer 4 is formed between the core layer 2 and the skin layer 3, characterized by comprising:

 a partial end portion 38 being curved inwards from a front portion of the skin layer 3 at a front end of the skin layer 3 that is correspond to a joint part between the core layer 2 and the skin layer 3; and

20 a foam leakage-preventing protrusion 24, for preventing a polyurethane foam from being leaking, protruding from an inner side surface of the core layer 2 which is correspond to the joint part between the core layer 2 and the skin layer 3, the foam leakage-preventing protrusion 24 being curved with corresponding to the shape of the partial end portion 38 of the skin layer 3;

wherein a foam staying space 40 for introducing the polyurethane foam therein is provided between the foam leakage-preventing protrusion 24 of the core layer 2 and the partial end portion 38 of the skin layer 3.

- 5 11. The join structure according to claim 10, characterized by the fact of flow control walls 21, 21', for preventing a polyurethane foam from being overflowed directly between the inner side surface of the core layer 2 and an end of the skin layer 3, downwardly protruding from an inner upper surface of the core layer 2 above the joint part of the core layer 2 and the skin layer 3.

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